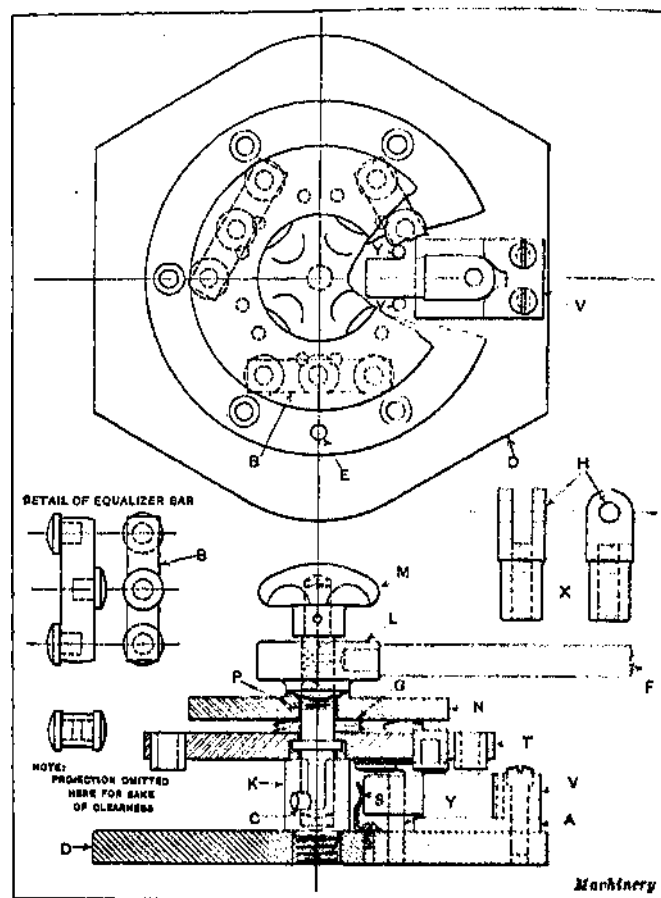


by hardened and ground steel pins. These rollers run on tracks which carry the jig under the machine and also enable it to be easily run back to remove the work.

It is necessary to drill quite a number of holes in the casting shown in place in the jig illustrated in Fig. 14, and these holes



**Fig. 15. Multiple Drill Jig for Yoke Bads**

are located on different sides and at various angles to one another. For this reason, an indexing jig is employed. This particular illustration shows the cover A of the jig removed in order to illustrate more clearly the position of the casting, which is located in

the jig by its trunnions. The  
main body of